

Date: Thursday, 5/3/2007 11:30:25 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	32168		Part Number	D2574		
Estimate Number	10534		Drawing Number	D2574 REV E		
P.O. Number	N/A		Project Number	N/A		
This Issue	5/3/2007	S.O. No.	N/A	Drawing Revision	E	
Prsht Rev.	NC	Type	MACHINED PARTS	Material	N/A	
First Issue	N/A			Due Date	5/22/2007	Qty: 12 Um: Each
Previous Run	32079					
Written By	A					
Checked & Approved By	A 07.05.03					
Comment	Est Rev: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <i>B 25358 (412) Sn of 10/02</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>B32168</i> Double check by: <i>SD</i> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <i>SD / 07/06/02</i>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <i>SD / 07/06/02</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SD / 07/06/02</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 32168

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/06/06 (12)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-06-07 (12)

7.0 POWDER COATING

POWDER COATING



m 104/144

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SR/SL

07-06-08

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/8 (12)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 433

PO 7/8 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

MS 07/06/11

Job Completion



MS 07/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 32168

Description: Saddle, Aft Inboard

Part Number: D2574

Inspection Dwg: D2574 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	-DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.750	1.748	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.746	1.750	1.749	1.750		
E	7.990	8.010		8.003	8.001	8.003	8.002		
F	0.490	0.510		0.500	0.502	0.500	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.500	0.497	0.497		
J	1.174	1.184		1.176	1.176	1.175	1.175		
K	0.558	0.578		0.567	0.564	0.561	0.567		
L	1.174	1.184		1.176	1.176	1.175	1.175		
M	1.365	1.375		1.366	1.368	1.367	1.366		
N	2.495	2.505		2.498	2.497	2.497	2.497		
O	4.119	4.129		4.122	4.121	4.122	4.121		
P	0.115	0.135		0.126	0.126	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.251	0.251		
S	0.115	0.135		0.126	0.121	0.124	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.240	0.238	0.236		
W	0.115	0.135		0.136	0.128	0.129	0.130		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.365	0.360	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.623	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.248	0.249		
AE	1.500	1.520		1.512	1.512	1.513	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.244	0.244	0.247	0.245		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *EP*

Audited by:

Date: 07/06/04

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>JLM</i>

DART AEROSPACE LTD	Work Order:	32168
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.741	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.749	1.749		
E	7.990	8.010		8.001	8.002	8.003	8.002		
F	0.490	0.510		0.500	0.500	0.503	0.503		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.496	0.500		
J	1.174	1.184		1.179	1.178	1.179	1.179		
K	0.558	0.578		0.570	0.569	0.570	0.570		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.121	4.121	4.122		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.251	0.249		
S	0.115	0.135		0.125	0.127	0.128	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.246	0.242	0.241	0.246		
W	0.115	0.135		0.134	0.134	0.135	0.135		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.366	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.247	0.247		
AE	1.500	1.520		1.512	1.513	1.512	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.260	0.260	0.265		
AH	0.240	0.260		0.247	0.250	0.249	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En 10ml
Date:	07/10/05

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

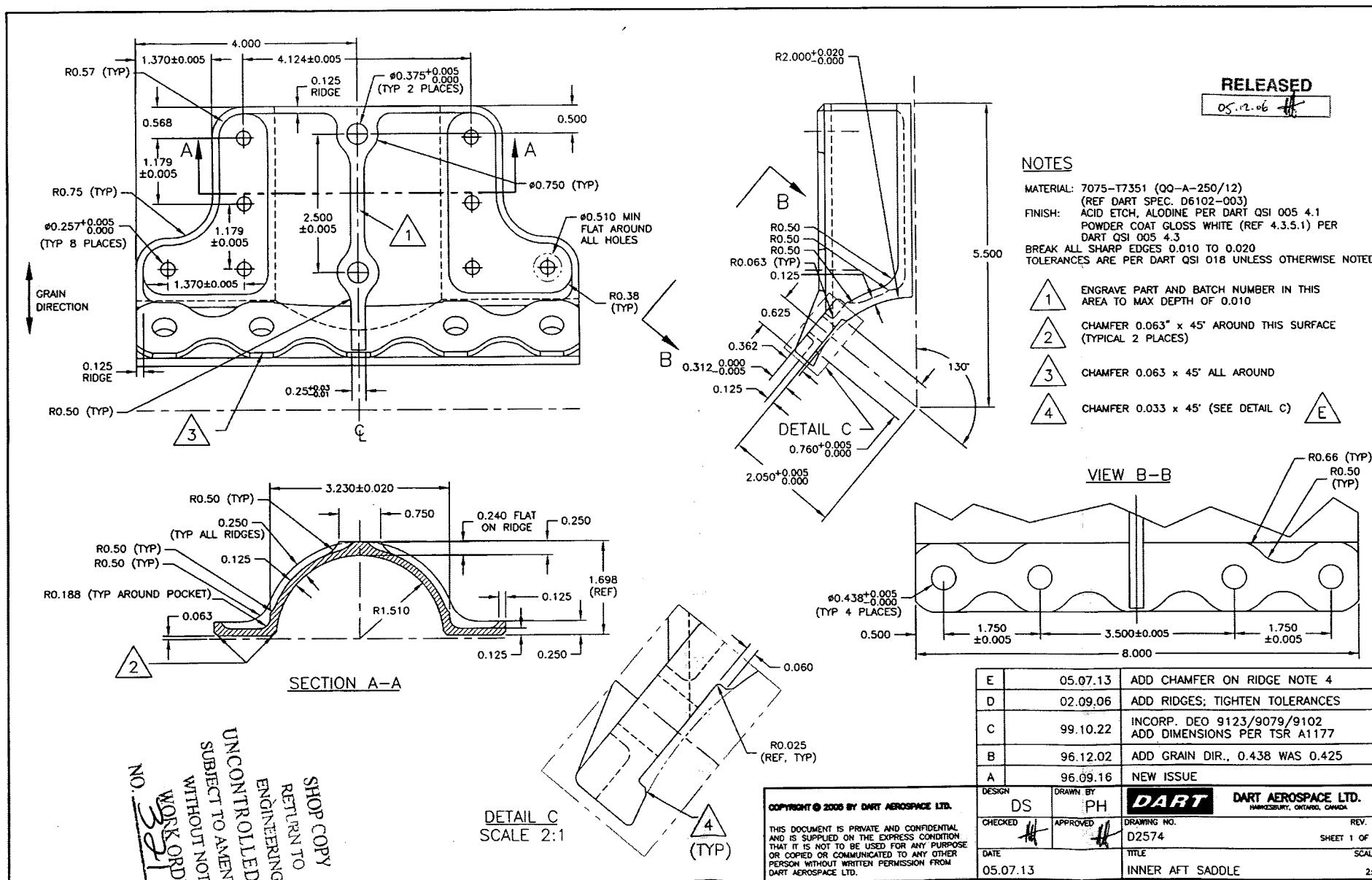
DART AEROSPACE LTD	Work Order:	32168
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.002	8.002	8.001	8.001		
F	0.490	0.510		0.503	0.503	0.502	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.503	0.503	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.571	0.570	0.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.122	4.121		
P	0.115	0.135		0.124	0.124	0.124	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.251	0.250	0.251		
S	0.115	0.135		0.124	0.126	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.238	0.240	0.239		
W	0.115	0.135		0.133	0.133	0.133	0.133		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.247	0.246		
AE	1.500	1.520		1.511	1.512	1.511	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.247	0.246	0.247	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>Chu</i>	Audited by:	
Date:	07/06/06	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>KA</i> <i>SM</i>	



COPYRIGHT © 2006 BY DART AEROSPACE LTD.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.